

**Work Order ID 80774**

Tuesday, February 28, 2012 3:05:45 PM

**\*80774\****March 8th*

Page 1

Item ID: D3913-041

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Long Basket Base Assembly, 350

Start Date: 2/28/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 3/7/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

*mf*

Date: 12-02-28 Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D3913

A

D4020

A

100

Weld per dwg A/R S.S. rod Batch: *1115778* 0.00**\*100\***

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3913 using DT9610A  
\*\*\*inspect before welding mesh\*\*\*  
2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913  
and trim mesh to fit if necessary and trim to clear fasteners holes on the ends  
3- weld hinge (3) and Mounting brackets as per dwg D3913  
\*\*\*take lid to locate hinge and bracket\*\*\*

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*110\***

QC

Memo

0.00

Quality Control

*Cpl 12-03-05 1x**12-03-05 1x*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Approvals: Process Plan:

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Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

**\*125\***

HandFinish

Memo

0.00

Hand Finishing

8/26/05

IXP M-L 12/03/06

W/O:		WORK ORDER CHANGES					
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QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*130\***

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 8-20OVEN TEMPERATURE: 400°FFINISH TIME: 8-30

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

1X 12/03/07

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

1 BL 12-3-7

W/O:		WORK ORDER CHANGES					
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Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

150

Assemble as per dwg

0.00

**\*150\***

HandFinish

Memo

0.00

Hand Finishing

Pick Kit

SP12-03-6

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

5.7/13/12

170

Identify as per dwg &amp; Stock Location:

D4030-046

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

80773.

1 BR 12-37.

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

MLO 12/03/08

MLO 12/03/08  
(1)

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Page 1

Work Order ID: 80774

Parent Item: D3913-041

Parent Item Name: Long Basket Base Assembly, 350

Start Date: 2/28/2012

Required Date: 3/7/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
verified by:EC

IPP Rev:B chg qty's DD 10.04.12

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2581  
Mounting Bracket

Manufactured No

100 Each 47.0000

2 2

Location

Loc Qty

Loc Code

WA005

47

69739

1

70766

2

77045

15

77523

29

*SY 12.02.29*

✓ D3913-1  
Rib

Manufactured No

100 Each 3.0000

1 1

Location

Loc Qty

Loc Code

WA006

3

74827

1

78039

2

*SY 12.02.29*

✓ D3913-15  
Wide Handle Plate

Manufactured No

100 Each 4.0000

1 1

Location

Loc Qty

Loc Code

WA005

4

74640

1

78321

3

*SY 12.02.29*

✓ D3913-3  
Rib

Manufactured No

100 Each 7.0000

1 1

Location

Loc Qty

Loc Code

WA006

7

69160

1

74904

1

78287

5

*78297*

*SY 12.02.29*

*1x*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 3/7/2012

Start Qty: 1.00

Required Qty: 1.00

✓	D3913-7	Manufactured	No	100	Each	8.0000	2	2	
✓	Rib								
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
				WA006		8			
				79416		8			
✓	D3913-9	Manufactured	No	100	Each	4.0000	1	1	
✓	Hinge Rib								
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
				WA006		4			
				70138		1			
				79876		3			
✓	D3916-041	Manufactured	No	100	Each	6.0000	2	2	
✓	Rib Assembly								
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
				WA006		6			
				69161		2			
				78494		4			
✓	D3916-5	Manufactured	No	100	Each	15.0000	3	3	
✓	Light Rib								
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
				WA		3			
				75305		3			
				WA006		12			
				78037		3			
				79908		9			
✓	D4016-1	Manufactured	No	100	Each	32.0000	3	3	
✓	Hinge Half, Base								
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>	
				WA005		32			
				75281		13			
				79413		19			

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 2/28/2012

Required Date: 3/7/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D4017-7  
Rib

Manufactured No

100 Each 5.0000 1 1

Location

Loc Qty

Loc Code

WA005

5

69730

1

74682

4

*LY* 12.02.29

✓ D4017-9  
Rib

Manufactured No

100 Each 12.0000 2 2

Location

Loc Qty

Loc Code

WA

6

79415

6

WA006

6

70341

2

73531

4

*LY* 12.02.29

✓ D4020-11  
End Mesh, Basket

Manufactured No

100 Each 14.0000 2 2

Location

Loc Qty

Loc Code

WA035

14

69648

2

78693

12

*LY* 12.03.05

✓ D4021-1  
Handle Plate

Manufactured No

100 Each 17.0000 3 3

Location

Loc Qty

Loc Code

WA

14

69518

0

74316

0

74946

0

79414

14

WA005

3

74986

3

*LY* 12.02.29

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Parent Item Name: Long Basket Base Assembly, 350

Start Date: 2/28/2012

Required Date: 3/7/2012

Start Qty: 1.00

Required Qty: 1.00

D4034-041 Manufactured No  
Aft Upper Rib Assembly

100 Each 2.0000 1

Location	Loc Qty	Loc Code
WA006	2	
78038	2	

*12-02-29*

D4034-043 Manufactured No  
Fwd Upper Rib Assembly

100 Each 2.0000 1

Location	Loc Qty	Loc Code
WA006	2	
78036	2	

*12-02-29*

M304EX0.75-16F Purchased No  
Expanded Metal Flat SS

100 sf 575.3277 33 33

Location	Loc Qty	Loc Code
WA	0.0001156	
119180	0.0001156	
WA035	575.3276036	
117197	102.9036	
117896	29.49258	
118153	76.8473	
118955	82.17	
119180	53.6958107	
119729	28.1132686	
120153	13.2387327	
120318	188.866312	

*12-03-05*

AN3-10A Purchased No  
Bolt

150 Each 88.0000 6

Location	Loc Qty	Loc Code
GA	84	
119084	84	
ST351	4	
117795	4	

*330*  
*SP*

*Lex*

AN960JD8 NAS1149DN832J Purchased No  
Washer

150 Each 0.0000 2

*m119717-2x*  
*SP 12-3-12*

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Required Date: 3/7/2012

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No 150 Each 502.0000 2  
Bumper

SP<sup>2</sup>

Location Loc Qty Loc Code

ST504 502  
46064 502

D4021-5 Manufactured No 150 Each 10.0000 2  
Blanking Plate

2x  
SP<sup>2</sup>

Location Loc Qty Loc Code

GA 10  
73478 10

MS20600-AD4W3 Purchased No 150 Each 1,316.0000 2  
Cherry Rivets

2x  
SP<sup>2</sup>

Location Loc Qty Loc Code

ST321 1183  
111636 36  
117505 10  
117601 35  
118626 602  
120308 500  
WA018 133  
107939 133

2x  
SP

MS21042L3 Purchased No 150 Each 4,059.0000 6  
Nut

SP<sup>6</sup> 12-03-6

Location Loc Qty Loc Code

ST300 4059  
117441 16  
117885 32  
118451 5  
118927 3  
119017 3806  
119075 197

6x

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Start Date: 2/28/2012

Required Date: 3/7/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

416.0000

12

12

WASHER

SP12-03-6.

Location

Loc Qty

Loc Code

ST275

416

117735

37

119225

176

120498

200

17317

3

12x

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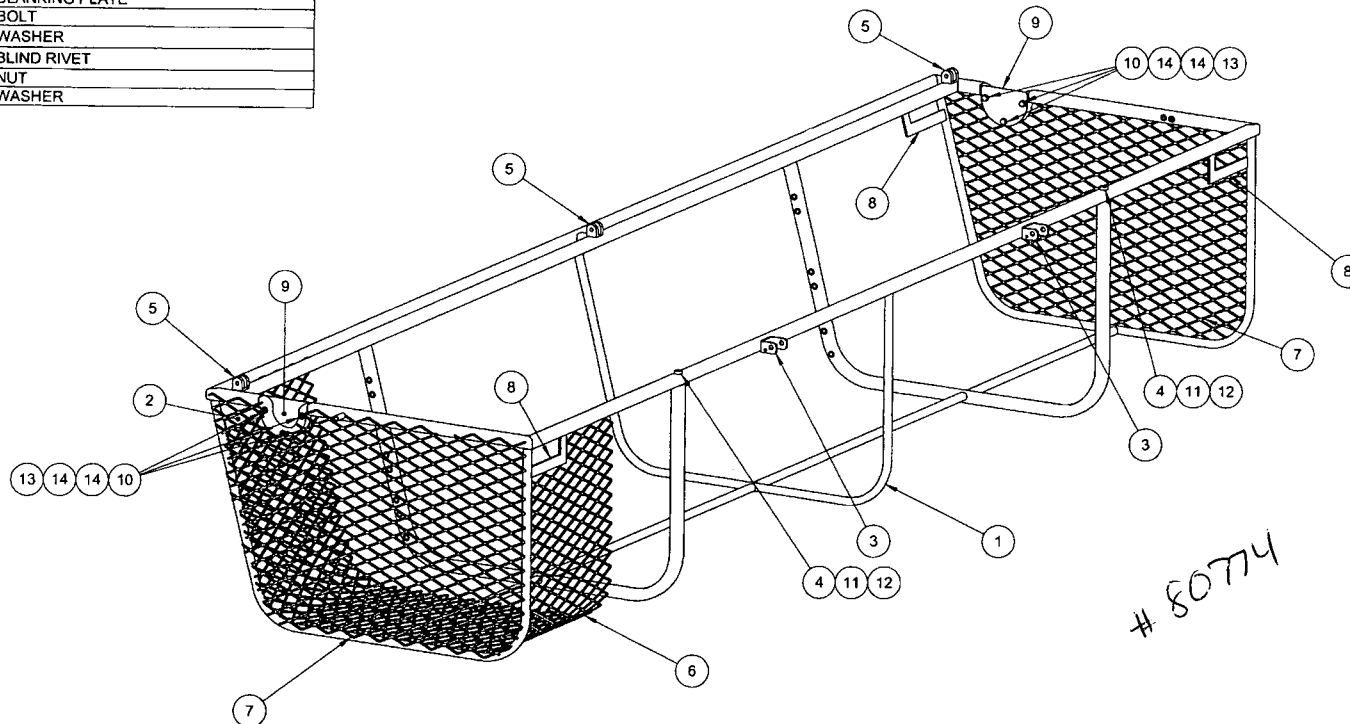
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

# 50774

**RELEASED**  
2010-03-22  
JWP

A	NEW ISSUE	JPH	10.03.16
REV	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

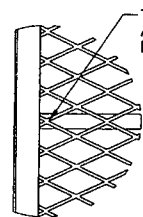
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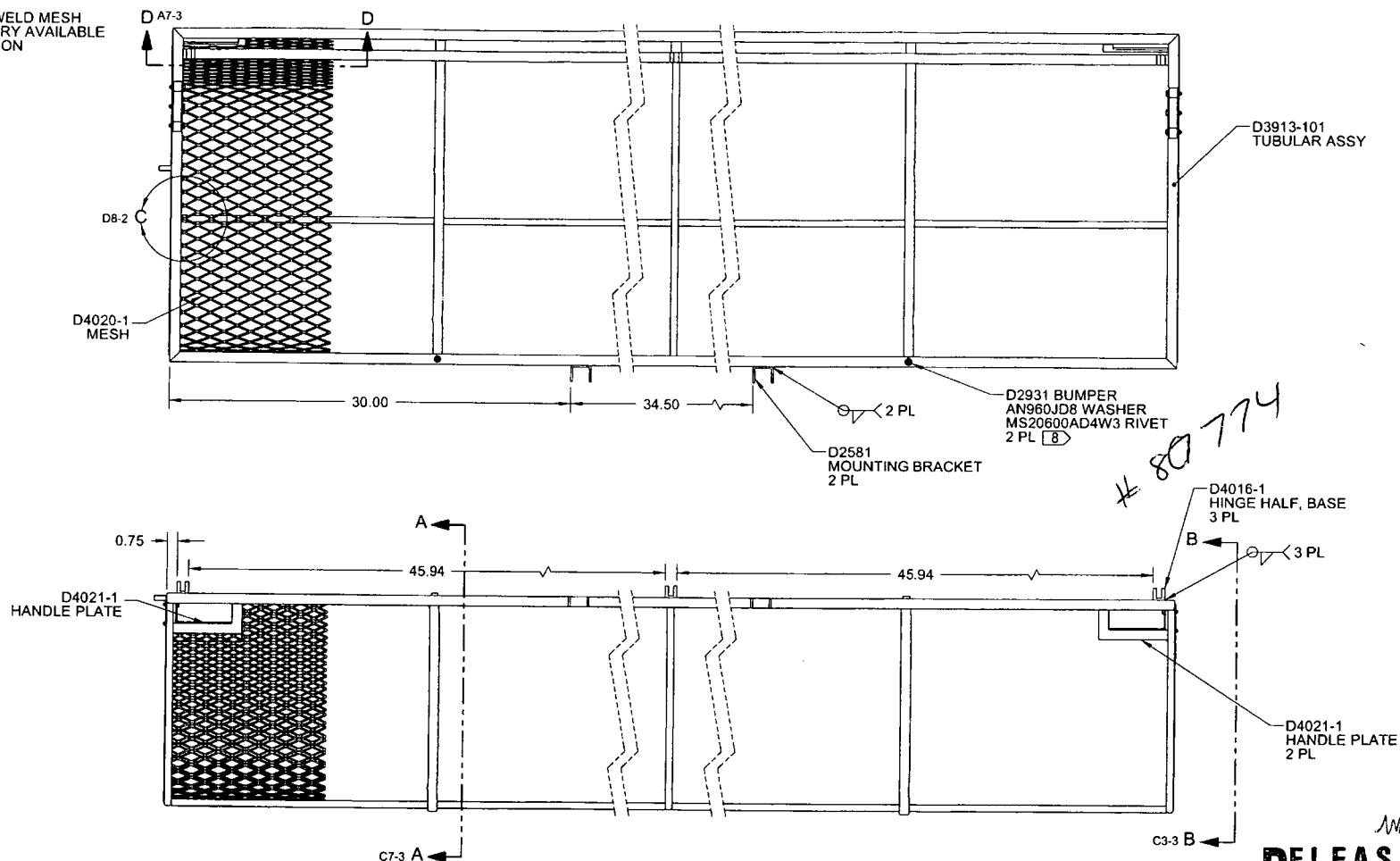
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries









**DETAIL C** D7-2



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2010-03-16

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JFH	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3913	SHEET 2 OF 6
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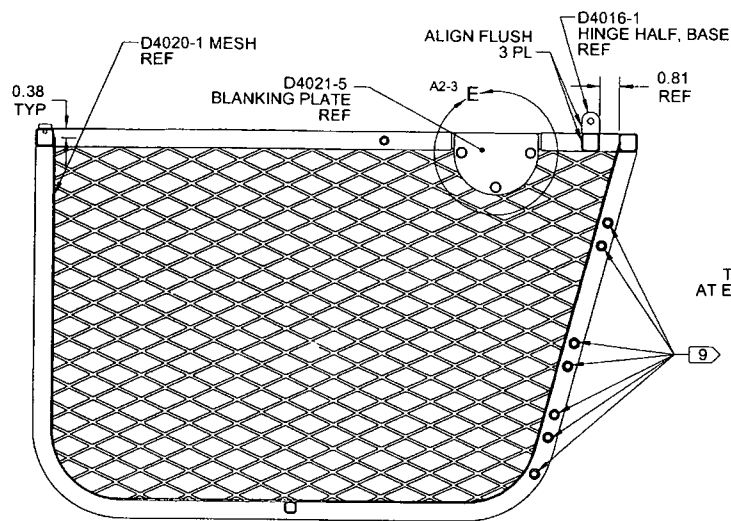
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

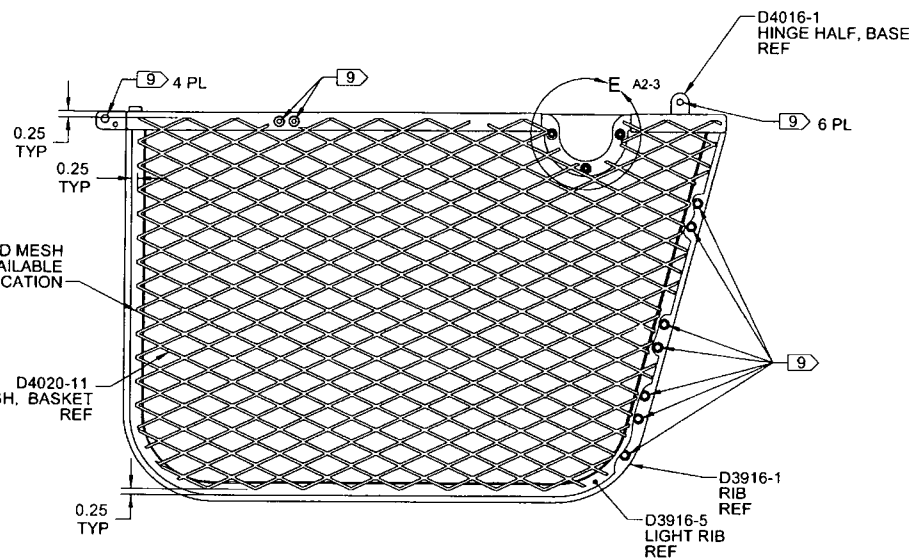
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

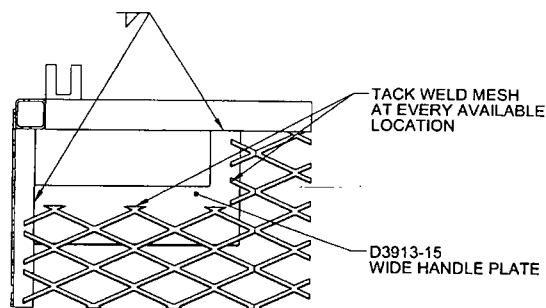
**NOTE:** Date & initial all entries



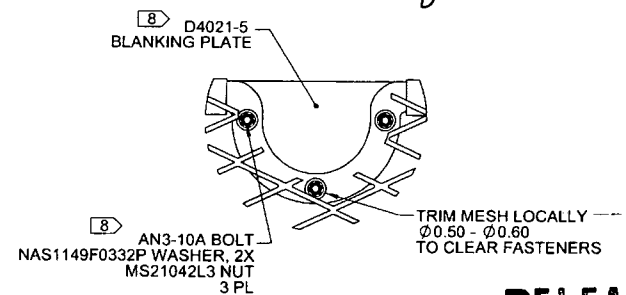
**SECTION A-A** A5-2



**VIEW B-B** A2-2



**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES



**DETAIL E** D2-3  
D6-3

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MFG. APPR.		D3913	SHEET 3 OF 6
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2010-03-22

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries .



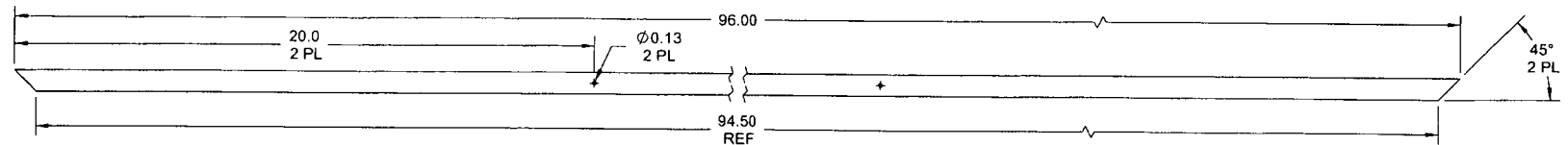
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

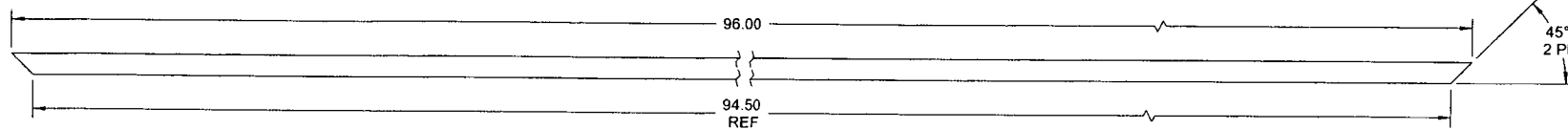
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

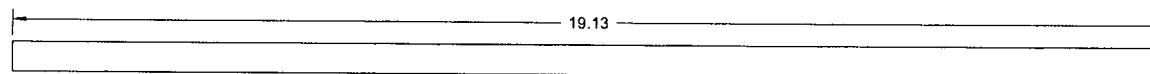


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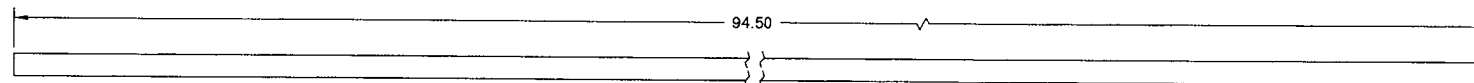
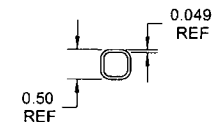
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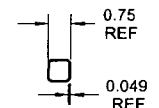
**D3913-3 RIB**



**D3913-7 RIB**



**D3913-9 HINGE RIB**



**NOTES:**

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

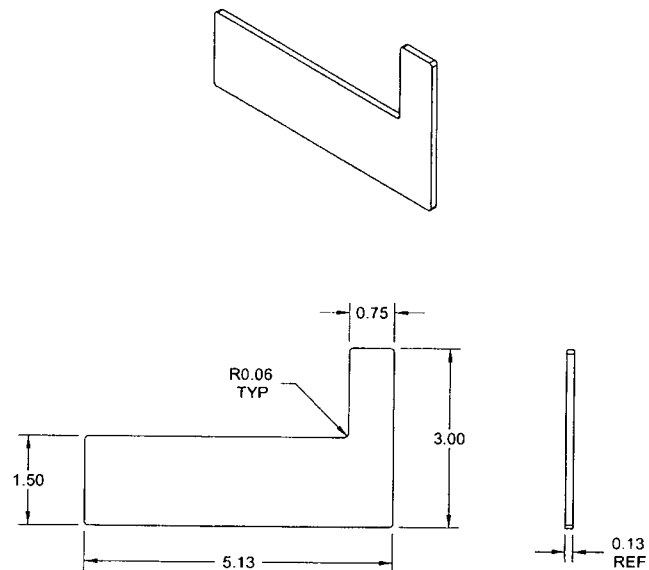
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO. <b>D3913</b>	REV. A
MFG. APPR.		SHEET 6 OF 6	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries